

# Work Order ID 50840

July 31, 2009 8:33:58 AM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Replacement Skidtube

Start Date: 08/06/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/28/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *MF* Date: *09-07-31*

Tooling:

Date:

Run Start



QC: Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

*N/A*

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

*1* *BE 09/07/31*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

(1)

2E 08/08/04

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

27 8 08/08/04

(10)

f

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
	Skidtubes								
Skidtubes									

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI 004  
A/R□□□ Aluminum Rod

M110295

BB 09/08/05

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill  
A/R□□□ Aluminum Rod

M110295

BE 09/08/05

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",  
adjust stopper not to hit web. Debur

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580.  
Debur holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

- ARV 9-8-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Reference:

Run Start



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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00  0.00	2) S 08/08/06			(6L)	4		
160  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00	2) S 08/08/06			(+L)	4		
170  HandFinish Hand Finishing	Pressure Wash per QSI005 4.3  Memo	0.00  0.00	2) 09-08-07			(T) III			

W/O:		WORK ORDER CHANGES					
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Page 5

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Customer:

Reference:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 8:20pm  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 8:50am

1112260

09-08-04

EU

W

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2.m 09 . 08 - 10 10

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Page 6

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of

Sikaflex on insert holes before installing wearplates

A/R ☐ ☐ ☐ Sikaflex-291 ☐ m111557

Sikaflex expire date: 10/01

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with

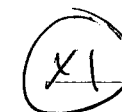
Sikaflex. Clean excess adhesive

A/R ☐ ☐ ☐ Sikaflex-291 ☐ m111557

Sikaflex expire date: 10/01

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: m112100



MD 09/08/10

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 7

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Item Name: Replacement Skidtube

Start Date: 08/06/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/28/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

=&gt; 8/2/09/11



220



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPPD205-634-041

Location:

PPP Rev:

PPC 50715

129/1/05 (1)

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/08/26

PPC

09-8-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

July 31, 2009 8:33:58 AM

Page 1 / 9

Work Order ID: 50840



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 08/06/2009

Required Date: 08/28/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2580-1RevD		Manufactured	No			110	Each	7.0000	1.0000			
205 Skidtube bent detail												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

7

48616

1

50760

6

D2576-3RevG

Manufactured No



140

Each

165.0000

1.0000

Step (maching detail)



Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

165

43504

62

46661

103

*B 50758 BE 09/08/05*

*1 BE 09/08/05*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector*

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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July 31, 2009 8:33:58 AM

Work Order ID: 50840

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube



Comments:

Start Date: 08/06/2009

Required Date: 08/28/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2579RevE		Manufactured	No			140	Each	412.0000	20.0000			
												
Crossbolt Spacer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	412
43988	4
46434	4
46956	12
47797	338
48272	54

20 26 09/08/05

D2855RevA

Manufactured No

200

Each

66.0000

1.0000



Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP6	52
50513	52

Main Warehouse

ST	14
10360	2
35663	7
41340	1
42343	3
42806	2
50513	-1

XI MD 09/08/10

W/O:		WORK ORDER CHANGES					
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AN3-5A 		Purchased	No			200	Each	2,560.000	2.0000			
Bolt												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

2560

100188

246

105057

2246

15205

68

✓2

MD 09/08/10

AN960JD10L



Washer

Purchased

No

200

Each

6,911.000

2.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6911

101291

16

104885

153

105793

236

109632

1506

110985

5000

✓2

MD 09/08/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector*

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

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Start Qty: 1.00

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ALS7-1032-130		Purchased	No			200	Each	3,706.000	50.0000			



Insert

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

105855

108606

111529

111779

3706

16

52

1638

2000

200

Each

2,071.000

50.0000

AN3C4A

Purchased

No



BOLT

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

112082

112314

2071

121

1950

X50 MD 09/08/10

X50 MD 09/08/10

July 31, 2009 8:33:58 AM

Shop Packet Print

Page 4

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AN960C10L  washer		Purchased	No			200	Each	4,591.000	50.0000			

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

100

103585

100

Main Warehouse

ST

4491

412116

4491

D3566-13RevC

Manufactured

No

200

Each

47.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

47

45717

1

46889

5

47435

7

48166

18

50265

16

150 MD 09/08/10

21 MD 09/08/10

July 31, 2009 8:33:58 AM

Shop Packet Print

Page 5

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D3566-5RevC		Manufactured	No			200	Each	22.0000	1.0000			
												
Gasket												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST	22	
36113	1	
46186	1	
47318	1	
48167	19	

D3566-1RevC

Manufactured No

200

Each

34.0000

2.0000



Gasket

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST	34	
46349	1	
47434	2	
48165	8	
48557	11	
50278	12	

~~X1~~ MD 09/08/10

X2 MD 09/08/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 7

July 31, 2009 8:33:58 AM

Work Order ID: 50840

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 08/06/2009

Required Date: 08/28/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-11RevD		Manufactured	No			200	Each	30.0000	1.0000			

Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 30

45823 1

47432 7

48553 12

50112 10

D3564-13RevD

Manufactured

No

200

Each

55.0000

1.0000

Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP17 35

48554 13

50270 22

Main Warehouse

ST 20

45409 3

46495 10

47867 7

xl mo 09/08/10

xl mo 09/08/10

July 31, 2009 8:33:58 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

July 31, 2009 8:33:58 AM

Work Order ID: 50840

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube



Comments:

Start Date: 08/06/2009

Required Date: 08/28/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-9RevD		Manufactured	No			200	Each	17.0000	1.0000			
												
Wearshoe												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST    17

44659    1

45825    1

47316    4

48556    11

D3564-5RevD

Manufactured      No

200

Each

22.0000

1.0000



Wearshoe

Warehouse                      Loc Qty                      Loc Code  
Location

OFFSHORE

FG    2

34806    2

Main Warehouse

FP19    12

48555    12

Main Warehouse

ST    8

45824    1

47433    1

48164    6

XI mp 09/08/10

XI mp 09/08/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 9

July 31, 2009 8:33:58 AM

Work Order ID: 50840



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 08/06/2009

Required Date: 08/28/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-3RevC		Manufactured	No			200	Each	894.0000	16.0000			
O-Ring, 205 Skidtube												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST                      894

27168                      44

29908                      850

D2594-1RevC

Manufactured      No

200

Each

700.0000

16.0000



Plug, 205 Skidtube

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST                      700

42221                      16

42807                      92

43884                      87

46435                      3

47251                      502

X16      mp 09/08/10

X16      mp 09/08/10

July 31, 2009 8:33:58 AM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

**RELEASED**  
07.06.28 *[Signature]*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
SEE NOTES ON  
PAGE 2 FOR D2580-041 AND  
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

*Handwritten:*  
#508210  
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RELEASED  
07-06-28

Diagram illustrating the grinding locations for the D2576-3 step. The diagram shows a cross-section of the step with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576
- $\frac{1}{4}$

Technical drawing of a circular base plate with a central hole and a rectangular cutout. The drawing includes dimensions and labels for components and materials.

Labels and dimensions:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)
- #0.208
- SEAL WITH SIKAFLEX-241/-291
- AN3-5A BOLT (1)
- AN960JDTOL WASHER (1) (2 PLACES)
- D2855 CAP
- 0.40

Diagram illustrating the assembly of the D2579 Spacer. The assembly consists of a central web (D2596 WEB (REF)) and a spacer (D2579 SPACER) which is inserted into the web. The spacer is secured by a nut and washer (D2579 NUT AND WASHER) on the opposite side. The assembly is shown with dimensions and a note regarding drilling and bending.

Dimensions and Notes:

- ALS7-1032-130 (REF) (TYP 50 PLACES)
- D2579 SPACER
- D2596 WEB (REF)
- PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:
  1. CHAMFER HOLE 0.050 X 45°
  2. INSERT D2579 SPACER (20 PLACES)
  3. WELD INTO PLACE AND GRIND FLUSH
  4. C'BORE D2579 SPACER TO 0.437 X 1.00 DEEP

[illegible]

D3560-01 ASSEMBLY DETAIL

WELD AS PER DETAIL B

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

0.5

1.5

1.5

0.5

8

1.5

1.5

1.5

P

P

P

P

P

P

P

REFER TO DETAIL C

D3566-1

D3566-5

D3566-1

D3566-13

D3564-11

D3564-5

D3564-9

D3564-13

AN3C4A BOLT (1)

AN960C10L WASHER (1)

(50 PLACES)

DESIGN	J	DRAWN BY	
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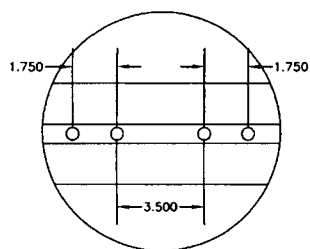
i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>
DATE			
07 02 27			

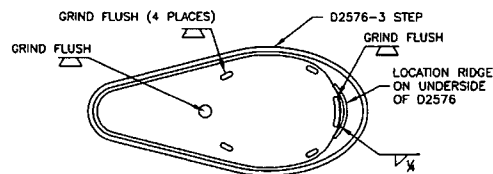
DRAWING NO.	REV. D
D2580	SHEET 2 OF 3
TITLE	SCALE
205 SKIDTUBE ASSEMBLY	1:24

**DETAIL E**  
SCALE 5:24

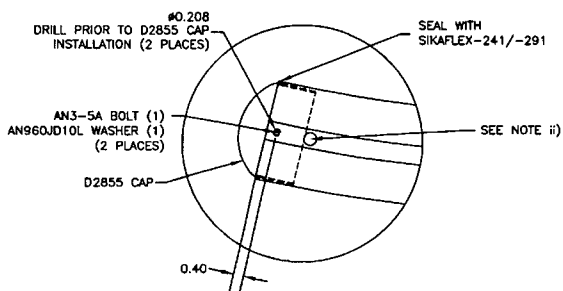


**RELEASED**  
07.06.28

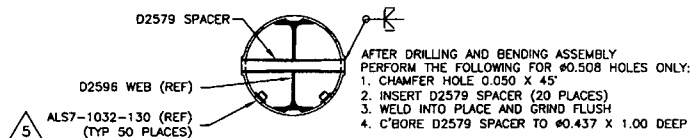
**DETAIL F**  
SCALE 5:24



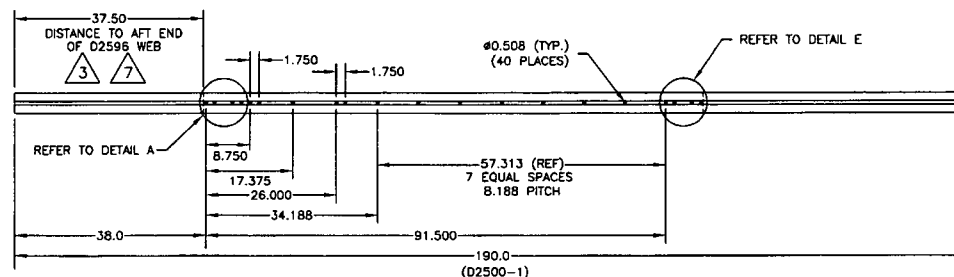
**DETAIL G**  
SCALE 5:24



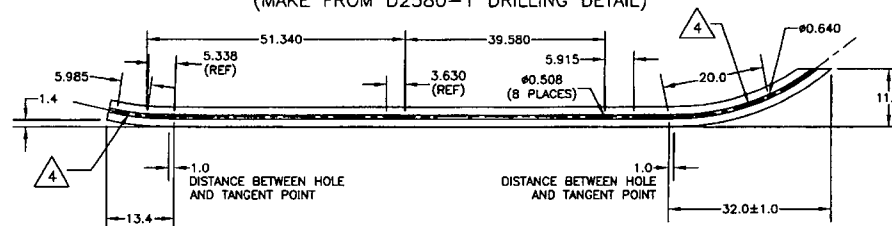
**SECTION H-H**  
SCALE 5:24



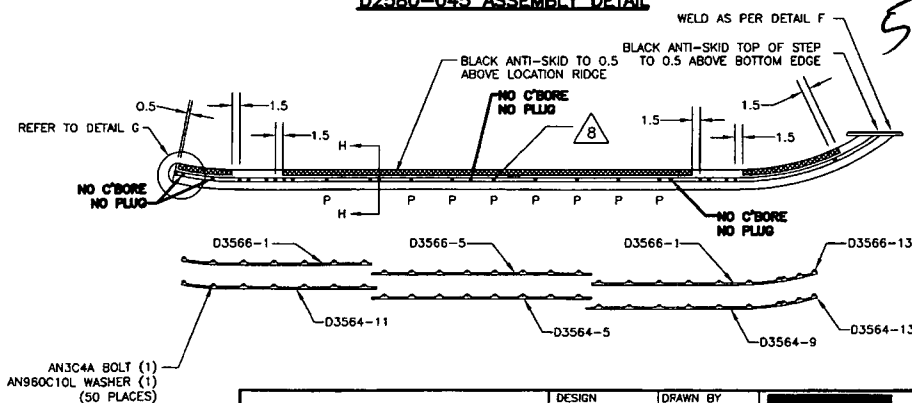
**D2580-1 DRILLING DETAIL**



**D2580-5 BENDING AND CUTTING DETAIL**  
(MAKE FROM D2580-1 DRILLING DETAIL)



**D2580-045 ASSEMBLY DETAIL**



50840

**D2580-045 NOTES**

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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DATE	TITLE	DRAWING NO.	REV. 0
07.02.27	205 SKIDTUBE ASSEMBLY	D2580	SHEET 3 OF 3
			SCALE 5:24

NO. 205

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barday Elliott  
Job number: D205 634 041 50335  
Part number: D205 634 041  
Description: 205 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier P.C. [Signature] Date of Test Coupon 09.07.30

Welder Barday Elliott Date of Test Coupon 09/07/30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld